

Date: Thursday, 01/05/2008 9:46:01 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SPACER		
Job Number	: 38925			Part Number	: D30661		
Estimate Number	: 10383			Drawing Number	: D3066 REV.B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 01/05/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 07/05/2008 Qty: 100 Um: Each		
Previous Run	: 38150						
Written By	:						
Checked & Approved By	: JLD 08-5-0						
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:B Now M6061-T6 06-06-23 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet <i>MAT NOT PULLED</i> Comment: Qty.: 0.0992 sf(s)/Unit Total : 9.9225 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080) Batch: <u>107711x61</u> ^{6.1} FB 8-5-6 <u>107276X</u>
2.0	WATER JET	FLOW WATER JET <i>(103)</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>FB 8-5-6</i> Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK <i>(103) counts</i>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 <i>BL 08/05/06 +103</i> Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>BL 08-05-07 (103)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  103X
Comment: INSPECT CHEMICAL CONVERSION COAT M-A 08/05/07		
7.0	PACKAGING 1	PACKAGING RESOURCE #1  103
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>WTF</u> 08-05-08		
8.0	QC21	FINAL INSPECTION/W/O RELEASE  08/05/21 JF
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		MF . 08-05-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38925
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>FB</u>	Audited by:	<u> </u>	Prototype Approval:	N/A
Date:	<u>8-5-6</u>	Date:	<u>8/5/06</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i>

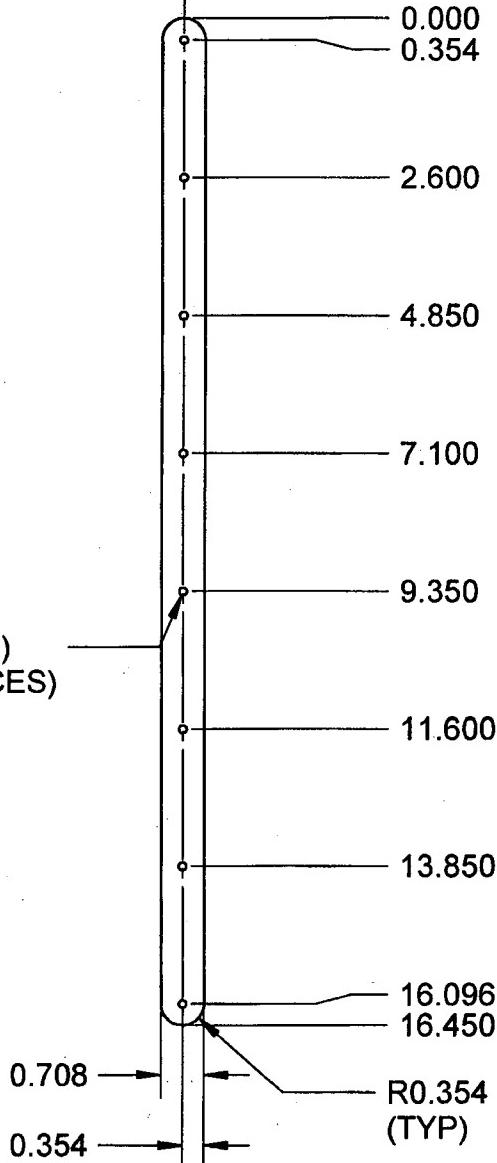
DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE SPACER	SCALE 1:3	

A	02.09.11	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL

RELEASED*06.06.20 - ff**(70)*

$\phi 0.128$ (#30)
(TYP 8 PLACES)

**D3066-1 SPACER**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38925

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